

# Work Order ID 62735

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Item ID: D350-607-043A

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/12/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-1	A								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-043A CHG001

Siakol/12

After BG 10-10-12

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

PULL FROM STOCK:  
1 X D350-607-043 B61856

10/10/12 SP

120

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

REMOVE PROP ARM D2332-041  
AND RETURN TO STK B

Row A

10/10/12 SP

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Item ID: D350-607-043A

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Start Date: 10/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/12/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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121

0.00



Large Fab

Memo

0.00

Large Fab

GRIND FLUSH D2327-3 BUSHING  
TRIM STEEL MESH LOCALLY A/R  
TRANSFER DRILL 2 X 0.194 HOLES THRU BASKET LID SQUARE TUBE  
AND 2 X 0.194 HOLES THRU BASKET BASE SQUARE TUBE PER DETAIL

DR 10-10-12.

Cpl 10.10.07

122

0.00



HandFinish

M115291

Start time: 9:30

Finish time: 1:00

temp: 16:00

Memo

0.00

Hand Finishing

TOUCH UP A/R

spray blk = M115193

wing walk = M115028

1 0

123

0.00



QC

QC3- Inspect Part Finish

Memo

0.00

Quality Control

Cpl 10/10/12

# Work Order ID 62735

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Item ID: D350-607-043A

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/12/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		81010112					
131  Small Fab Small Fab	Memo RE-ASSEMBLE AS PER DRWG D350-607 TO MAKE D350-607-043A PER ICA PG17-18	0.00  0.00							81010112 (U)
132  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		81010112					



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Item ID: D350-607-043A

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/12/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/12  
JMF  
10-10-12

# Picklist Print

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Work Order ID: 62735



Parent Item: D350-607-043A



Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/06/10

Required Date: 10/12/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevB: as per dwg revC DD 10.01.18 verified by:EC  
per dwg revC DD 10.01.18 verified by:EC  
545 DD 10.04.19 verified by:EC  
IPP RevC: as  
IPP rev:D as per ecn10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D350-607-043

Manufactured

No

Each

2.0000



Heli-Utility-Basket

Location

Loc Qty

Loc Code

FG

1

39328

1

61442

1

D350-607-143

Manufactured

No

110

Each

1.0000



Automatic Lid Opener Installation

Location

Loc Qty

Loc Code

FG032

1

54041

1

1  
EP 510/10/12  
61856 (K)

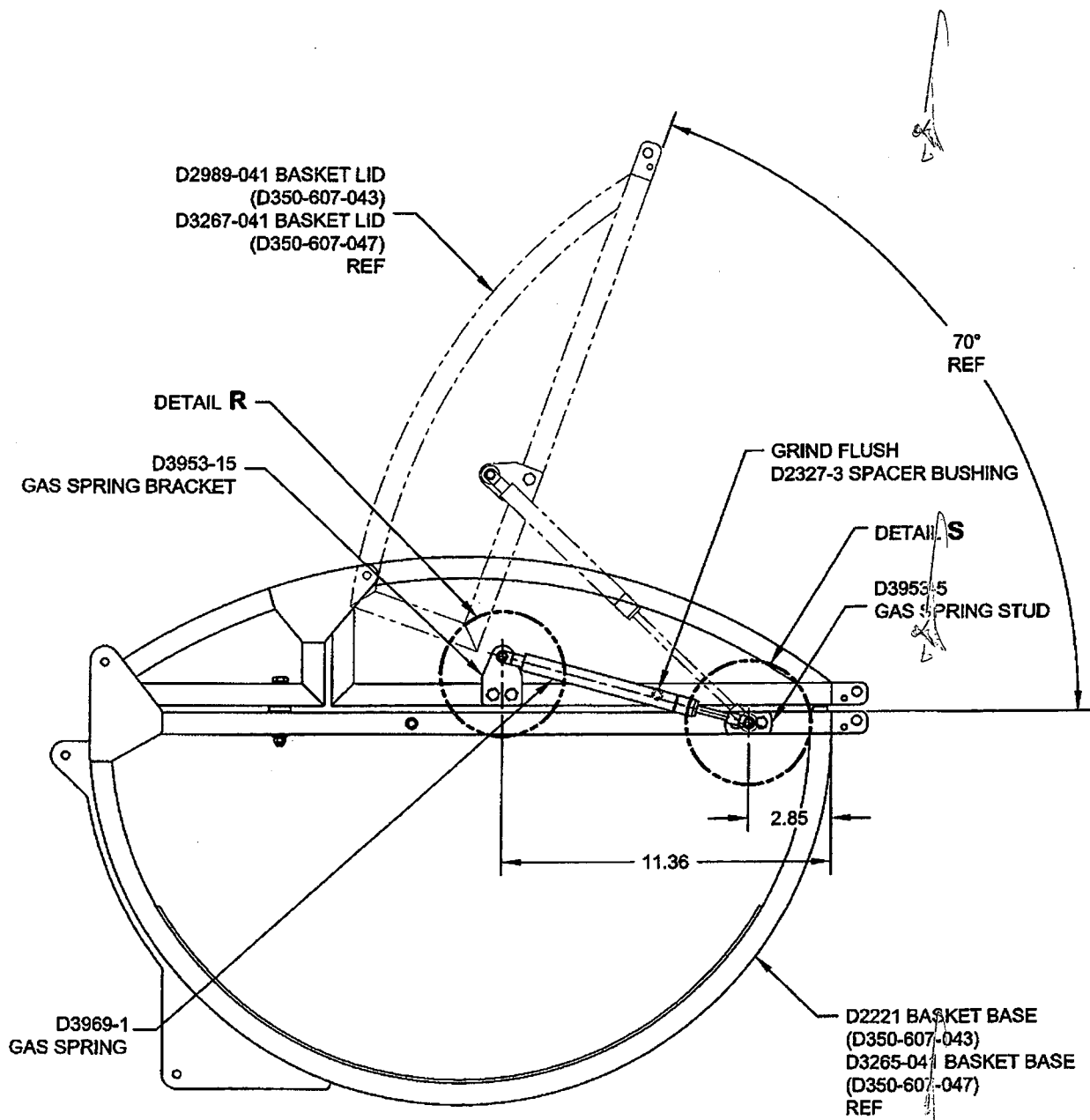
1  
EP 510/10/12  
BC 2734 (K)

Signature

Signature

Signature

Signature



**D350-607-143 AUTOMATIC LID OPENER INSTALLATION**  
(1 END ONLY)

**Figure 9a – Automatic Lid Opener Installation**

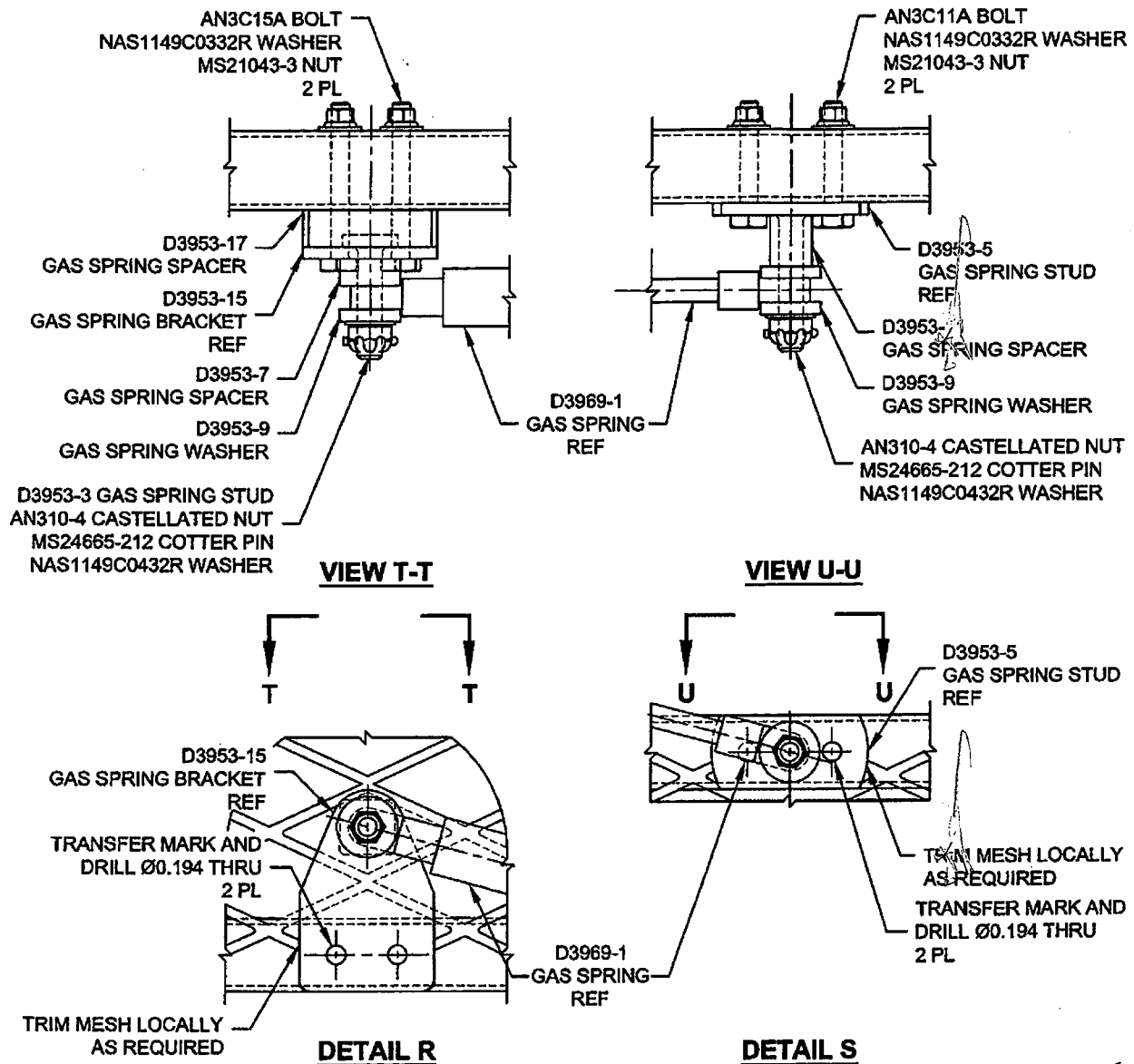


Figure 9b – Automatic Lid Opener Installation



## 2.0 GENERAL NOTES

### COMPATIBILITY

Compatibility of this installation with the aircraft is the responsibility of the installer. Ensure that this installation does not conflict with a previous modification.

### CONTINUING AIRWORTHINESS

This installation should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D350-607.

## 3.0 INSTALLATION PROCEDURE

For installation of D350-607-041/-041A/-043/-043A/-045/-045A/-047/-047A *Heli-Utility-Basket™*.

- 3.1 **NOTE:** For aircraft equipped with high gear, the Dart *Heli-Utility-Basket™* is compatible with Dart D350-591 high-gear steps. The D350-591 step height must be set as shown in Figure 1 to ensure that the cargo doors will open with the basket installed. For aircraft equipped with low gear, the Dart *Heli-Utility-Basket™* is **not** compatible with Dart D350-591 low gear steps; any Dart low gear step will have to be removed before basket installation.
- 3.2 The D350-607-041/-043/-045/-047 *Heli-Utility-Basket™* may be installed on either the LH or RH side of the aircraft. For RH installations, the D2332-041 Prop Assembly should be moved to the aft end of the basket. Use existing hardware and ensure nuts face aft.
- 3.3 Install the D2732-030 Rubber Cushions, D2230-1 Lugs and D2324 Strut onto the basket as shown in Figures 2 and 3, using the AN4 hardware shown.  
**NOTE:** The AN4-15A bolts may be replaced with a stainless steel positive locking quick release pin with a minimum double shear strength of 2400 lbs and with a 1.0 inch grip length and 0.25 inch diameter (Avibank: BLC4B10S, BLC4TA10S, BLC4R10S, BLC4LA10S; MS Number: MS17984C410, MS17985C410, MS17986C410, MS17987C410)
- 3.4 Present the basket to the crosstubes. Propping the basket at the appropriate height can facilitate installation. If the basket is being installed on high gear with Dart D350-591 steps, temporarily place a 0.063" (1.6mm) shim on the step and rest the basket on the shim. Remove shims after bolts are torqued.
- 3.5 Attach the basket with the D2230-3 Clamps and AN4 hardware shown in Figure 2 and 3. Leave bolts loose to allow for adjustment.
- 3.6 Tighten clamp bolts once height is positioned properly. Do not exceed torque of 60 in-lb (6.8 Nm) on the nuts. **CAUTION:** Over-torquing the nuts could lead to structural damage of the clamps.

## 4.0 INSTALLATION OF OPTIONAL KITS

### 4.1 D350-607-141 AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET)

**NOTE:** Once this modification is complete you will not be able to re-install the D2332-041 Prop Arm.

- 4.1.1 Remove the D2332-041 Prop Arm.
- 4.1.2 Grind Flush the D2327-3 Spacer Bushing on both ends of the Basket as shown in Figure 8a (it is permissible to grind all 4 Spacers Flush). Touch up paint Per ICA-D350-607 Section 5.1 Item 4.
- 4.1.3 Locate the D3953-1 Gas Spring Bracket as shown in Figure 8a. Trim Steel Mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket lid square tube structure as shown in Detail M. Install the D3953-1 Gas Spring Bracket & D3953-13 Gas Spring Spacer using 2X AN3C16A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 NUT as Shown in View P-P.

- 4.1.4. Locate the D3953-5 Gas Spring Stud as shown in Figure 8a. Trim Steel Mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer Mark and Drill 2X Ø0.194 holes thru the Basket base square tube structure as shown in Detail L. Fasten D3953-5 IAW View N-N using 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut.
- 4.1.5. Install 1X D3953-11 Gas Spring Spacer onto the D3953-5 Stud as shown in View N-N. Install the large end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud and Fasten in Place using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View N-N. Install Cotter Pin per MS33540 or AC43.13 chapter 7-127.
- 4.1.6. Insert the D3953-3 Gas Spring Stud into the D3953-1 Gas Spring Bracket & Insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring as Shown in View P-P. Raise the Basket lid and install the rod end of the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View P-P. Install Cotter Pin Per MS33540 or AC43.13 Chapter 7-127.
- NOTE:** The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
- NOTE:** With the lid in the closed position the Gas Spring should not be fully compressed.
- 4.1.7. Repeat steps 4.1.2 through 4.1.6 at the other end of the Basket.
- 4.1.8. Test the installation. If installed properly the Gas Springs should assist the Basket user in both opening and closing the basket lid.

#### 4.2 D350-607-143 AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)

**NOTE:** This kit may be installed at either end of the Basket. However, the Prop Arm must be removed in either case as it will interfere with the function of the Gas Spring.

- 4.2.1 Remove the D2332-041 Prop Arm.
- 4.2.2 Grind flush the D2327-3 Spacer Bushing on the end of the Basket where the lid opener is to be installed as shown in Figure 9a (it is permissible to grind all 4 spacers flush). Touch up paint per ICA-D350-607 Section 5.1 Item 4.
- 4.2.3 Locate the D3953-15 Gas Spring Bracket as shown in Figure 9a. Trim steel mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket Lid Square tube structure as shown in Detail R. Install the D3953-15 Gas Spring Bracket & D3953-17 Gas Spring Spacer using 2X AN3C15A BOLT, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View T-T.
- 4.2.4 Locate the D3953-5 Gas Spring Stud as shown in Figure 9a. Trim Steel Mesh Locally as required. Touch up paint per ICA-D350-607 Sections 5.1 Item 4. Transfer mark and drill 2X Ø 0.194 holes thru the Basket Base square tube structure as shown in Detail S. Install 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View U-U. Install the rod end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud using 1X D3953-9 Gas Spring washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View U-U. Install Cotter Pin per MS33540 or AC43.13 Chapter 7-127. 62735
- 4.2.5 Insert the D3953-3 Gas Spring Stud into the D3953-15 Gas Spring Bracket & insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring Stud as shown in View T-T. Raise the Basket lid and install the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud and fasten in place using 1X D3953-9 Gas Spring Washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View T-T. Install Cotter Pin per MS33540 OR AC43.13 Chapter 7-127.
- NOTE:** The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
- NOTE:** With the lid in the closed position the Gas Spring should not be fully compressed.